

Ship by June 29

Work Order ID 71191

Thursday, June 23, 2011 11:20:06 AM



Item ID:	D3277-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Window					
Start Date:	6/23/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	6/28/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3277	Rev A								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3277								
	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B11-6-28

(4)

B11-6-29

5/16/28

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71191

Thursday, June 23, 2011 11:20:06 AM



Page 2

Item ID: D3277-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

0.00



Small Fab

Memo

0.00

Small Fab

ENGRAVE P/N AND B/N AS PER DWG

6/24/06/28 (4)

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/11/06/29

(4)

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

6/24/06/29 (4)

11/06/29

W/O:		WORK ORDER CHANGES					
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Item ID: D3277-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/29

11-06-29
(4)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:20:03 AM

Page 1

Work Order ID: 71191

Parent Item: D3277-1

Parent Item Name: Window



Start Date: 6/23/2011

Required Date: 6/28/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.03.22 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	287.4934	5.174	21.78526	22		



1/8" Polycast II Sheet



B11-6-28

4

Location

Loc Qty

Loc Code

MAT

142.2467

117431

142.2467

MAT018

142.2467

117324

68.7667

117340

73.48

MAT019

3

115338

3

117324 x 2
117340 x 2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

7491

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

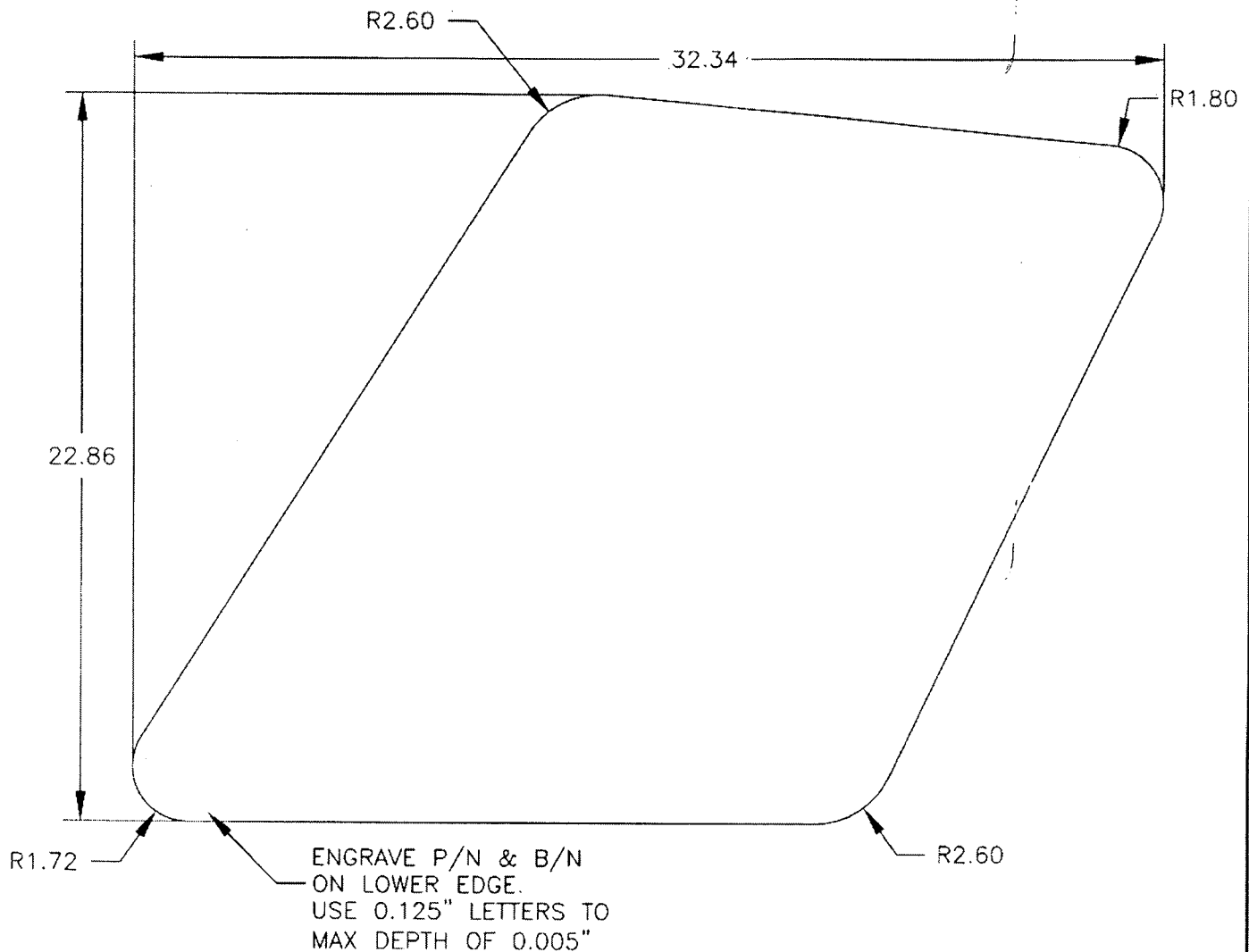
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3277	REV. A SHEET 1 OF 1
DATE 04.08.23		TITLE CREW WINDOW (R44)	SCALE 1:5
A	04.08.23	NEW ISSUE	

RELEASED
05 03 18 *HH*



D3277-1 WINDOW

- 1) CUT PER TEMPLATE D3277-1T1
- 2) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.125 THICK
(REF DART SPEC. M-ACRYLIC-S.125)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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